

Work Order ID 138698

Monday, November 09, 2015 12:44:09 PM

138698

Page 1

Item ID: PB67-43001-63

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Handle Assy

Start Date: 11/9/2015 Start Qty: 7.00

~~*7*~~ 3

Cust Item ID:

Required Date: 11/27/2015 Req'd Qty: 7.00

~~*7*~~

Customer:

Reference:

Approvals:

Process Plan: MEDate: 15-11-9

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

B67-43001-63

Rev C

100

0.00

100

Large Fab

Large Fab

Large Fab

Memo

M/31562

0.06

- 1- chamfer both ends (0.090") on -129 and -127
- 2- chamfer (0.090") only the angle end on -157
- 3- drill #40 hole in center of -129 before welding -131 caps, to let air out
- 4- weld -131 to -129 as per dwg
- 5- grind weld flush
- 6- assemble -127 under the pilot hole in -129 and -157 weld as per dwg
- 7- grind weld flush
- 8- install rivet as per dwg
- 9- assemble by drilling thru both -157 and -133 as per dwg
- 10- install spring slotted pin as per dwg

3

FEB 16 2016

DAS
24
9-89

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Quality Control

Memo

0.00

3

DAS
43
9-89

FEB 17 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

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Page 3

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N900040100

Setup Start

NS1

Revision ID:

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Item Name: Handle Assy

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Required Date: 11/27/2015 Req'd Qty: 7.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: MEZZ 0.00

150

Packaging

Memo

0.00

Packaging

3 MLJ 16-02-25

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.01

Quality Control

MLJ FEB 26 2016

MLJ FEB 26 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
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Picklist Print

Monday, November 09, 2015 12:44:07 PM

Page 1

Work Order ID: 138698

138698

Parent Item: PB67-43001-63

PB67-43001-63

Parent Item Name: Handle Assy

Start Date: 11/9/2015

Required Date: 11/27/2015

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP Rev:A 08-07-29 new issue DD verified by:ec
10.09.30 per rev C dwg EC verified by:DD

IPP rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-129		Manufactured	No			100	Each	3.0000	1	13			DAS
PB67-43001-129									**			FEB 12 2016	24 9-09
Tube Handle													

Location Loc Qty Loc Code

Mezz2

3

133720

3

PB67-43001-127

Manufactured

No

100

Each

4.0000

1

PB67-43001-127

**

FEB 12 2016

DAS
24
9-09

Handle Arm

Location Loc Qty Loc Code

Mezz2

4

133719

4

PB67-43001-157

Manufactured

No

100

Each

6.0000

1

PB67-43001-157

**

FEB 12 2016

DAS
24
9-09

Tube

Location Loc Qty Loc Code

Mezz2

6

131373

6

PB67-43001-131

Manufactured

No

100

Each

3.0000

2

PB67-43001-131

**

FEB 12 2016

DAS
24
9-09

Tube End Cap

Location Loc Qty Loc Code

Mezz2

3

113000

3

B139 142 → 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐
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Misidentified ☐	☐	Past Due ☐	☐				

Picklist Print

Monday, November 09, 2015 12:44:07 PM

Page 2

Work Order ID: 138698

138698

Parent Item: PB67-43001-63

PR67-43001-63

Parent Item Name: Handle Assy

Start Date: 11/9/2015

Required Date: 11/27/2015

Start Qty: 7.00

Required Qty: 7.00

PB67-43001-133

Manufactured No

100

Each

5.0000

1

7

PR67-43001-133

Clevis

FEB 16 2016

DAS

24

9-89

Location

Loc Qty

Loc Code

Mezz2

5

133210

1

133721

4

240-107

Purchased

No

100

Each

108.0000

1

7

240-107

SPRING SLOTTED PIN

FEB 16 2016

DAS

24

9-89

Location

Loc Qty

Loc Code

ST568

108

m132006

108

CR3213-4-2

Purchased

No

100

Each

544.0000

1

7

CR3213-4-2

Cherry Rivet

FEB 16 2016

DAS

24

9-89

Location

Loc Qty

Loc Code

CCK003

192

123301

192

ST319

352

m131340

352

DQA: _____ Date: _____

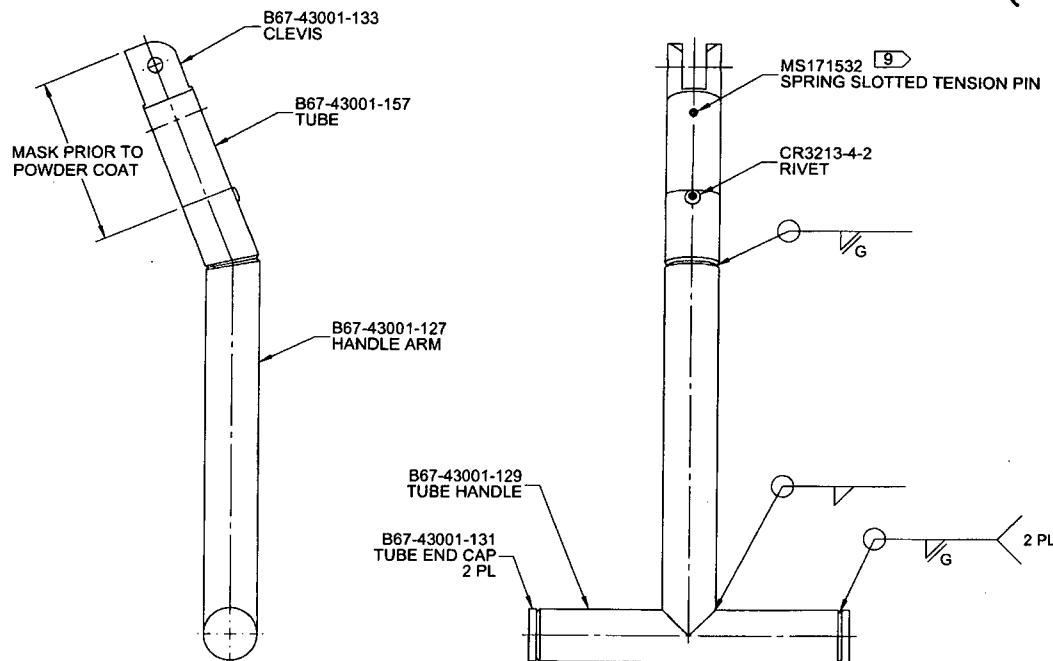


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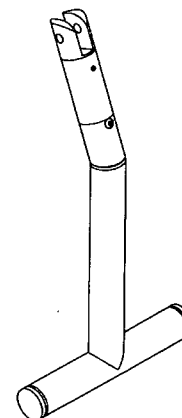


B67-43001-63 SHORT T-HANDLE ASSEMBLY

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT "GREEN SANDTEX" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.46 lbs
- 8) WELDING: PER DART QSI 004
- 9) ALIGN B67-43001-133 AS SHOWN. ENLARGE PILOT HOLE LOCATED ON HANDLE AND DRILL THRU B67-43001-157-133. DRIVE MS171532 IN TO HOLE.

ITEM	QTY -63	P/N	DESCRIPTION
1	X	B67-43001-63	SHORT T-HANDLE ASSEMBLY
3	1	B67-43001-129	TUBE HANDLE
4	1	B67-43001-127	HANDLE ARM
5	1	B67-43001-157	TUBE
6	2	B67-43001-131	TUBE END CAP
7	1	B67-43001-133	CLEVIS
9	1	MS171532	SPRING SLOTTED TENSION PIN (OR 240107)
10	1	CR3213-4-2	RIVET



RELEASED
R 2010-09-16
MP

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 15 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.06.10
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED	RIS	DRAWING NO.	REV. C	
MFG. APPR.		B67-43001-63	SHEET 1 OF 1	
APPROVED	AW	TITLE	SCALE	
DE APPR.	N/A	SHORT T-HANDLE ASSEMBLY	NTS	
DATE	09.06.10	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

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